

Date: Thursday, 6/1/2006 8:36:37 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOUBLER KIT	
Job Number :	27323F			
Estimate Number :	11455			
P.O. Number :	N/A	Part Number :	D314068	
This Issue :	6/1/2006	Drawing Number :	D3140 REV D1	
Prsht Rev. :	NC	Project Number :	N/A	
First Issue :	N/A	Drawing Revision :	D1	
Previous Run :	2520A	Material :	N/A	
Written By :	<i>See Comment Below</i>		Due Date :	6/8/2006
Checked & Approved By :	<i>06.06.07</i>		Qty:	1
Comment :	Est. B 02/11/13 Removed D3140-65/-81/-83; Added D3140-301 K			
	J			
	Est. Rev C New dwg rev. ecn781 06.04.18 EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D314010	Doubler Assembly
-----	---------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Doubler Assembly

Pick:

Qty	Part Number	Description	Batch
1	D3140-10	Doubler Assy	<i>26727</i>

2.0	D3140101	
-----	----------	--



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Doubler

Pick:

Qty	Part Number	Description	Batch
2	D3140-101	Doubler	<i>26723</i>

3.0	D3140241	Doubler
-----	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Doubler

Pick:

Qty	Part Number	Description	Batch
1	D3140-241	Doubler	<i>18470</i>

4.0	D3140303	Doubler
-----	----------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Doubler

Pick:

Qty	Part Number	Description	Batch
			<i>26798</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/1/2006 8:36:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER KIT

Job Number: 27323F

Part Number: D314068

Job Number:



Seq. #:

Machine Or Operation:

Description :

2

D3140-303

Doubler

26798 /

5.0

D314087

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Pick:

Qty Part Number Description Batch

1 D3140-87 Doubler

25729 /

6.0

D314092

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Pick:

Qty Part Number Description Batch

1 D3140-91 Doubler

25730 /

7.0

D314095

Doubler



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Doubler

Pick:

Qty Part Number Description Batch

3 D3140-95 Doubler

25731 /

8.0

D314098

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Pick:

Qty Part Number Description Batch

1 D3140-97 Doubler

26724 /

9.0

D314099

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Pick:

Qty Part Number Description Batch

1 D3140-99 Doubler

26722 /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/1/2006 8:36:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER KIT

Job Number: 27323F

Part Number: D314068

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D3140104

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3140-104	Doubler	25739

11.0

D3140106

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3140-106	Doubler	25738

W 0606-28

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 206/04/28 1

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FG

C 206/04/28 1

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

206/06/01

Job Completion



u 06-08-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
DI	06.03.31	1.75 WAS 1.88; 4.75 WAS 4.13	

RELEASED
05.12.01 *[Signature]*

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. 0 SHEET 2 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED
05.12.01

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

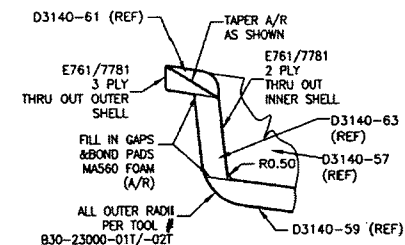
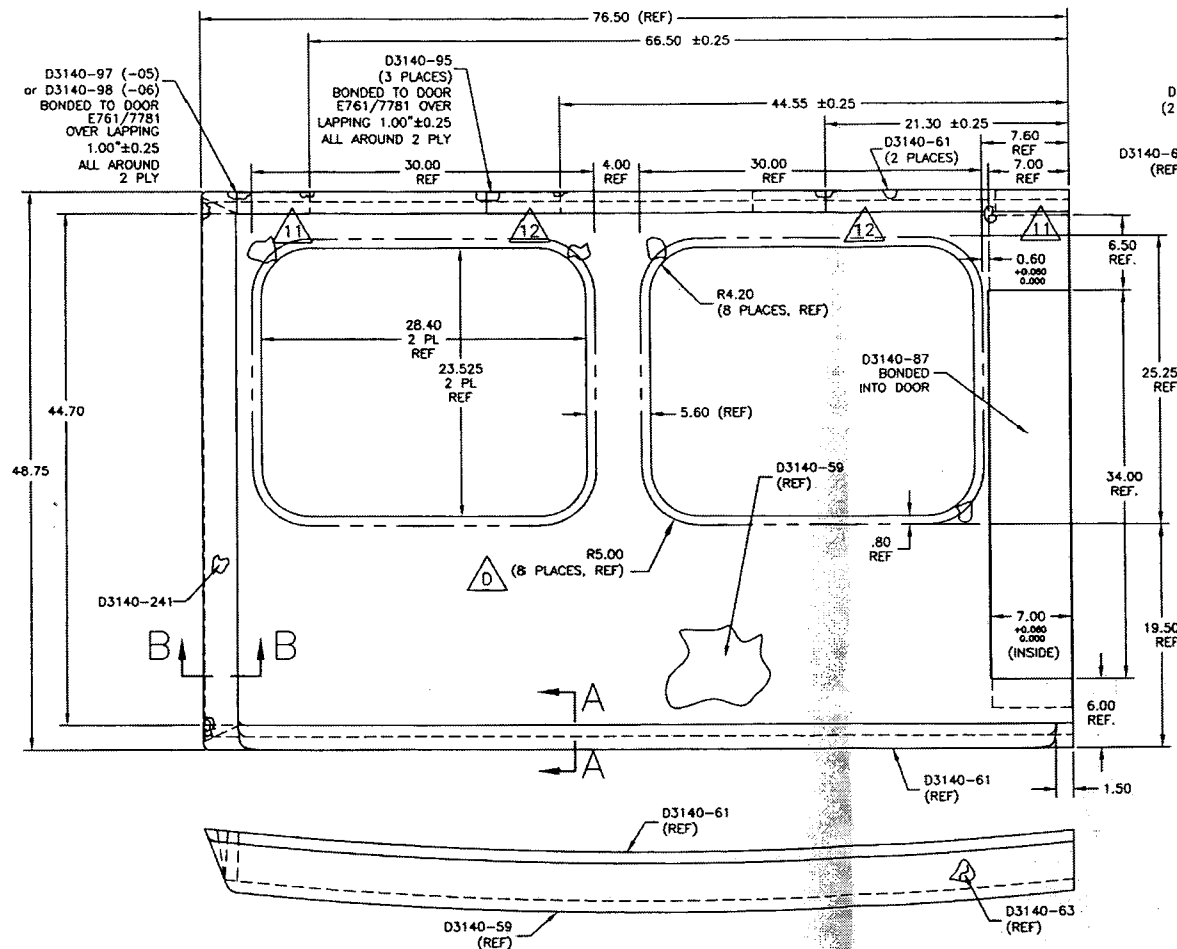
13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

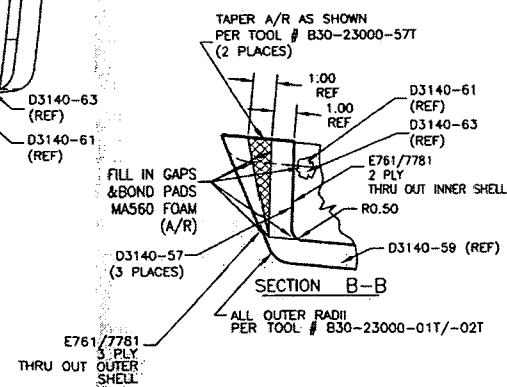
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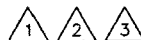
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D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

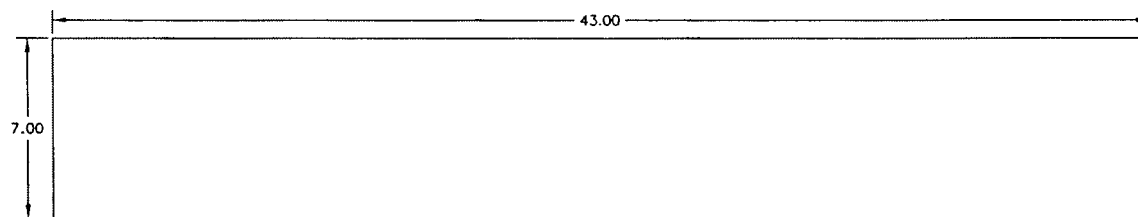


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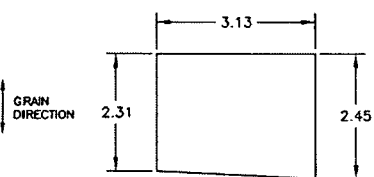
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CHECKED	#	APPROVED	#	DRAWING NO.	D3140
DATE	05.11.23	TITLE	DOOR	REV. 0	SHEET 3 OF 7
				SCALE	NTS

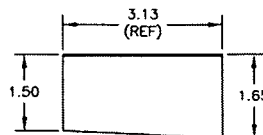
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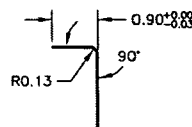
D3140-87 DOUBLER $\triangle 4$
(REPLACES PREMIER P/N B30-23000-87)



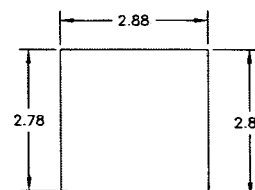
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



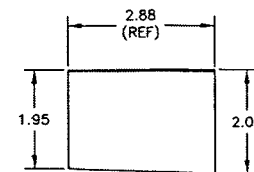
D3140-105 DOUBLER
D3140-106 OPPOSITE



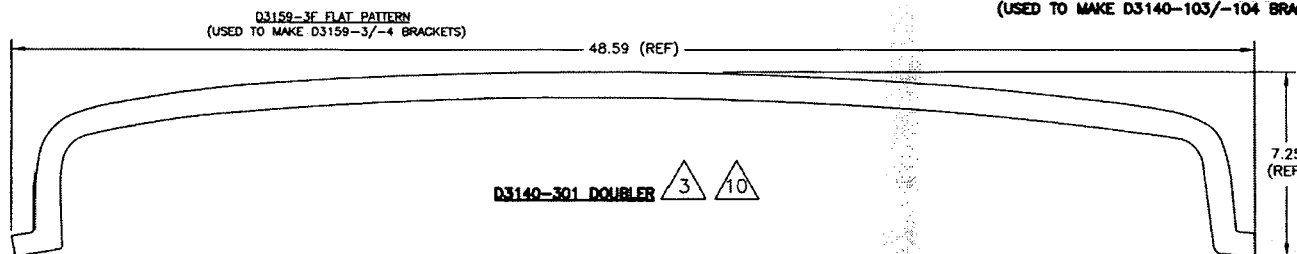
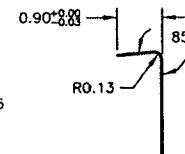
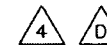
GRAIN DIRECTION



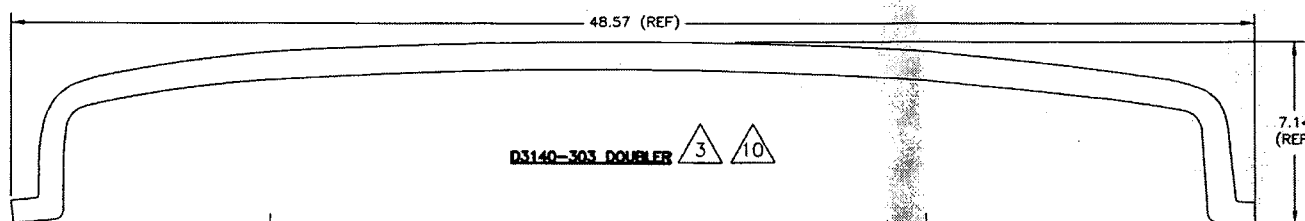
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



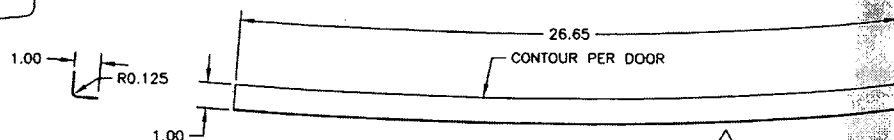
D3140-103 DOUBLER
D3140-104 OPPOSITE



D3140-301 DOUBLER $\triangle 3$ $\triangle 10$



D3140-303 DOUBLER $\triangle 3$ $\triangle 10$



D3140-85 ANGLE $\triangle 6$
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

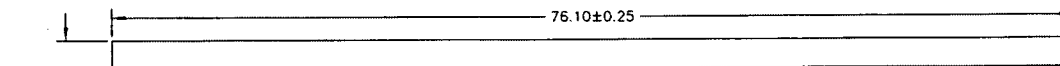
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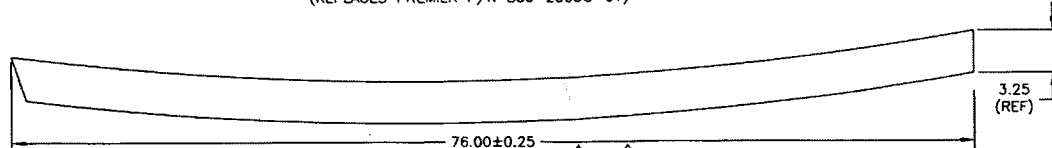
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CHECKED 	APPROVED 	DRAWING NO. D3140	REV. D SHEET 6 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS

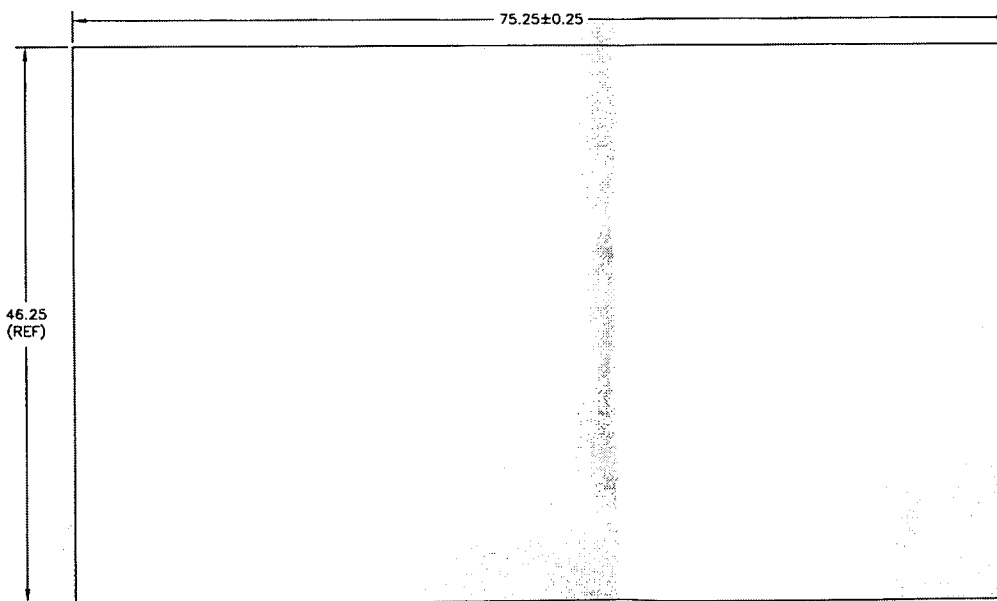
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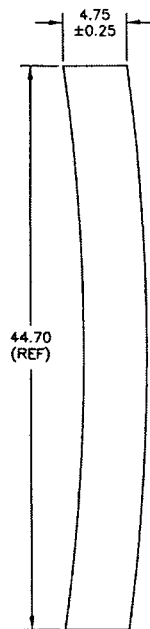
D3140-61 PAD 3 7
(REPLACES PREMIER P/N B30-23000-61)



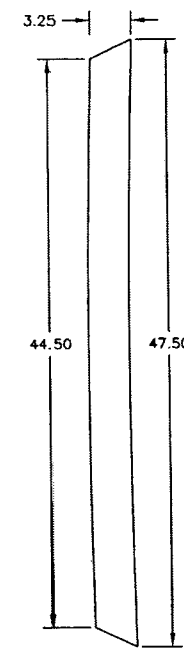
D3140-63 PAD 3 7
(REPLACES PREMIER P/N B30-23000-63)



D3140-59 PAD 7
(REPLACES PREMIER P/N B30-23000-59)



D3140-57 PAD
(REPLACES PREMIER P/N B30-23000-57)
3 7



D3140-241 DOUBLER 5
(REPLACES PREMIER P/N B30-23000-241)

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		DATE 05.11.23	TITLE DOOR	REV. D SHEET 7 OF 7 SCALE NTS

A/S Linda
DART (613) 632-3336

N° DE COMMANDE - ORDER NO.		REP. - DEPT.	DATE 06.04.20
VENDU À - SOLD TO		EXPÉDIE À - SHIP TO <i>Dalstein</i>	
ADRESSE - ADDRESS		ADRESSE - ADDRESS	

DATE D'EXPÉDITION - SHIPPING DATE	VIA	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REC. NO	VENDEUR - SALES PERSON
2	D3140-99	B	26722	
4	D3140-101	B	26723	
1	D3140-97	B	26724	
1	D3140-98	B	26725	
2	D3140-241	B	18470	
1	D3140-10 includes D3140-85 / 84	B	26727	
1	D3140-303	B	26798	
1	D3140-301	B	26797	
<i>301</i> <i>303</i>				
28 AVR. 2005				
<i>April 28/06</i>				
TPS/GST				
TVP/PST				
TOTAL				

104619

SIGNATURE

N° LIC. - UC. NO.

Bluebird DCR/CS

FORMULAIRE DE VENTE - SALES ORDER